

Work Order ID-86434

\*86434\*

Page 1

June-28-12 1:03:15 PM

Item ID: D2916-7

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Cable Guard, 212 Skidtube

Stop \*NS2\*

Start Date: 28/06/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2916

Rev D

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2916 Dwg Rev: 0 Prog Rev: 0 2-  
Deburr if necessary

UHMW 1" Blk

21.38" x 1.75"

110 +1-0.030

QC-2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

0.00

\*120\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

BATCH: 86434 1- Mill as per Folio FB077 Rev: AA  
& Dwg D2916 Rev: D 2-Deburr per dwg D2916

2012-12-21

2012-12-21

B12-7-8

Stamp

Stamp

Stamp

Stamp

Stamp

Stamp

Stamp

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W/O: 86434		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 102916-7 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: OK Date: 13/1/14  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed Date: 1

NCR: 13-2170		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-12-19	100	blanks from water jet too short, supposed to be 21.38" length between 21.272 to 21.280 4 pieces	S 052412 12/12/19	Scrap + replace x4 B 123949	Jm 12-12-19	OK 12/12/23	S 052412 12/12/15	S 12/12/15
		<del>P.C. Blank cut too short on water jet</del> N/A		Fix Blank cutting Program				
		yes it is cut too short - not the program		\$120.30				

NOTE: Date & initial all entries

June-28-12 1:03:15 PM

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**Item Name:** Cable Guard, 212 Skidtube

Stop \*NS2\*

**Start Date:** 28/06/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 12/07/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 86434

**\*86434\***

Page 3

June-28-12 1:03:15 PM

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Setup Start **\*NS1\***

Revision ID:

Item Name: Cable Guard, 212 Skidtube

Stop **\*NS2\***

Start Date: 28/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*MCS 13-01-03*

*13-01-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-28-12 1:03:18 PM

Page 1

Work Order ID: 86434

\*86434\*

Parent Item: D2916-7

\*D2916-7\*

Parent Item Name: Cable Guard, 212 Skidtube

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-19 JLM  
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	72.0100	0.26	1.094737	2.		

\*MUHMWB10\*

UHMW-1" Black

\*\*

12-7-8

Location	Loc Qty	Loc Code
MAT018	48.9	
120972	1	
121346	27.1	
121954	20.8	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

122286

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	410434
<b>Description:</b> Cable Guard		<b>Part Number:</b>	D2916-7
<b>Inspection Dwg:</b> D2916	<b>Rev:</b> PD 4/12.06.28	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.75	+/-0.030	1.753	✓			JFC-01
	21.38	+/-0.030	21.38	✓			31006
	1.000	+/-0.010	1.000	✓			JFC-01
	17.375	+/-0.010	17.375	✓			JFC-01
F-F	0.70	+/-0.030	0.704	✓			"
	0.78	+/-0.030	0.780	✓			"
	0.95	+/-0.030	0.953	✓			"
	12.84	+/-0.030	12.838	✓			31006
	14.65	+/-0.030	14.645	✓			"
	16.47	+/-0.030	16.468	✓			"
	18.28	+/-0.030	18.28	✓			"
L-L	Ø0.438	+0.006/-0.001	0.438	✓			JFC-01
	0.78	+/-0.030	0.780	✓			"
	0.95	+/-0.030	0.952	✓			"
	0.70	+/-0.030	0.704	✓			"
	0.080	+/-0.010	0.083	✓			"
N-N	0.850	+/-0.03	0.850	✓			"
N-N	0.080	+/-0.010	0.083	✓			"
N-N	0.340	+/-0.03	0.336	✓			"

<b>Measured by:</b> JFC B.A.	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 2022-12-21	<b>Date:</b> 12/12/23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D205-665-015	KJ/RF	
B	12.03.08	Dimensions updated per Dwg Rev D	KJ [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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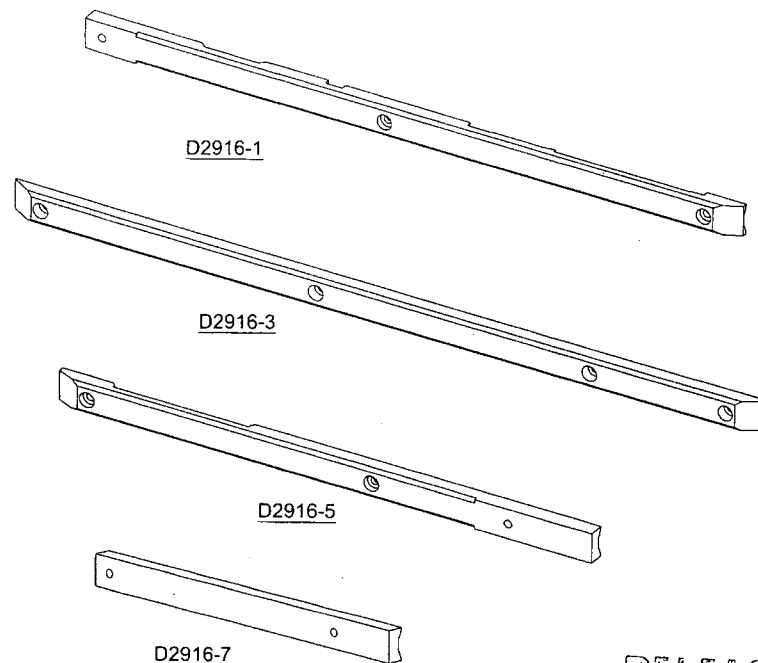
WORK ORDER  
NO. 86434 ML5  
12/06/28

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL  
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT:

D2916-1 = 1.37 lbs  
D2916-3 = 2.33 lbs  
D2916-5 = 1.19 lbs  
D2916-7 = 0.96 lbs

- 8) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) MACHINE CONSTANT SECTION B-B
- 11) MACHINE CONSTANT SECTION C-C
- 12) MACHINE CONSTANT SECTION F-F
- 13) MACHINE CONSTANT SECTION G-G
- 14) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 15) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 16) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 17) ALL HOLES DRILLED ON CENTERLINES



RELEASED  
R 2011-11-02  
MP

D	REVISE MACHINE SLOT. (ZN C5-2, C4-4, C4-5, C6-5) REVISE SECTIONS D-D, L-L, N-N	RF	11.10.07
C	REVISE D-D; ADD L-L, M-M & N-N; FOR D4406-041/-043 COMPATIBILITY	RF	11.08.17
B	ADD K-K FOR D2521 COMPATIBILITY	CP	00.02.24
A	NEW ISSUE	CP	99.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>4</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>4</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>4</u>	D2916	SHEET 1 OF 6
APPROVED	<u>4</u>	TITLE	SCALE
DE APPR.	<u>4</u>	CABLE GUARD	NTS
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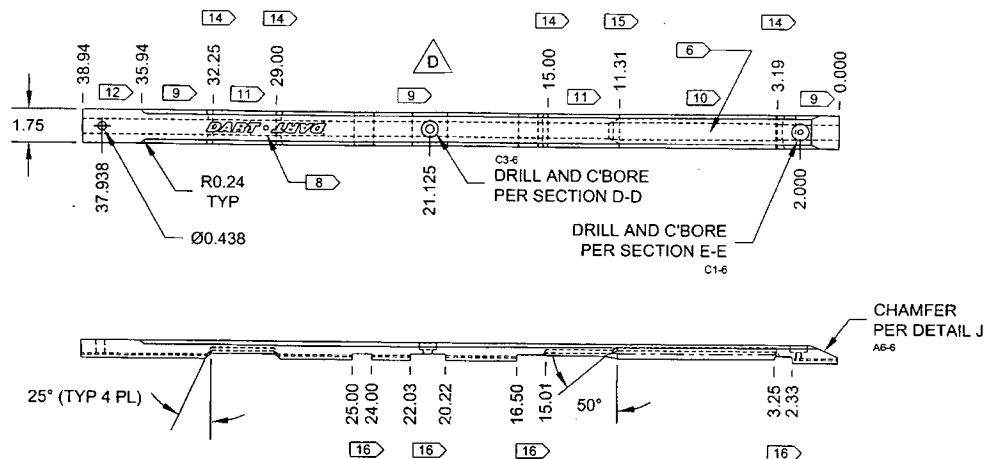
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D2916-1

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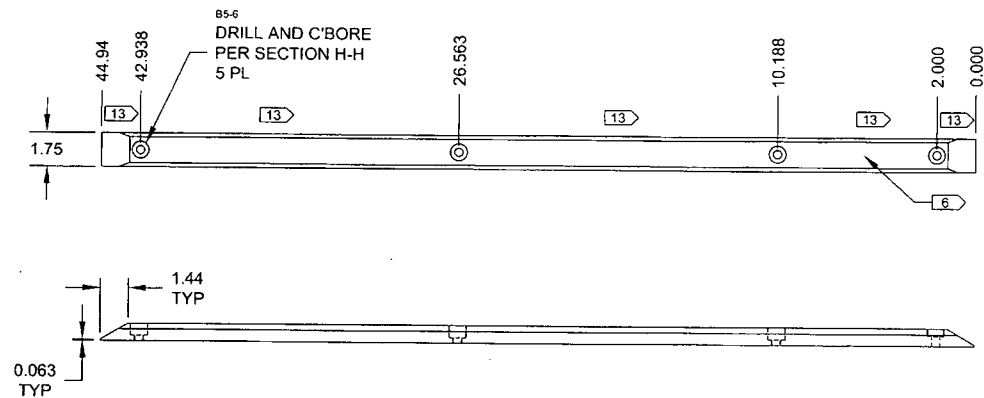
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

26434



**D2916-3**

**RELEASED**  
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

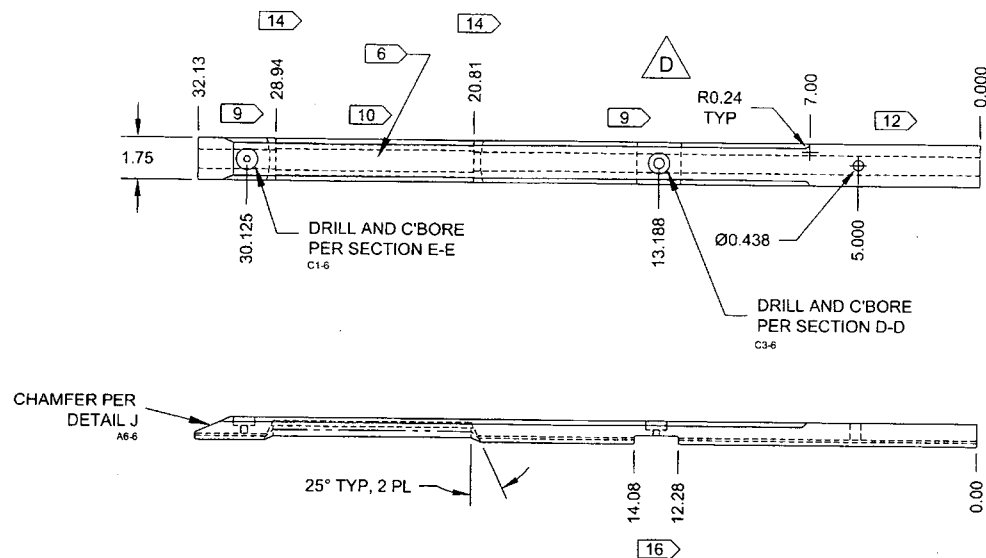
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**D2916-5**

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2011-11-02  
JND

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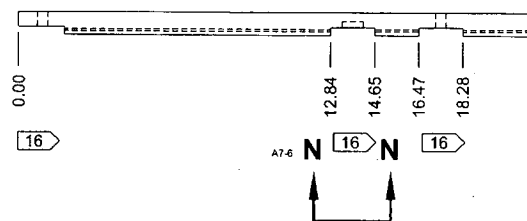
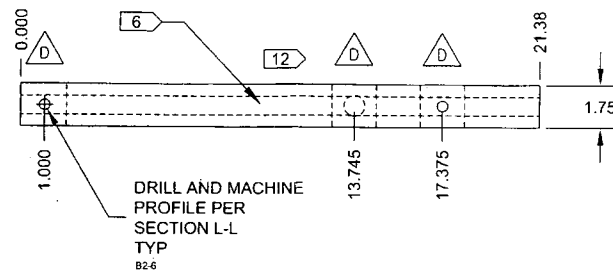
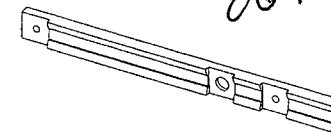
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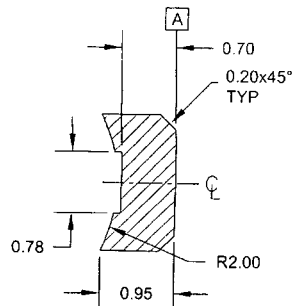
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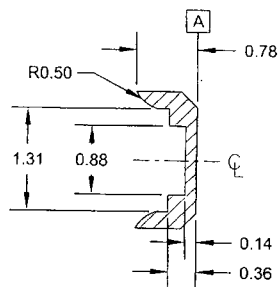
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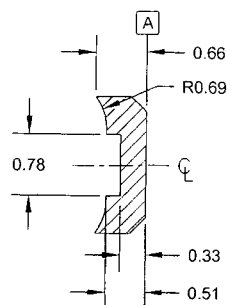
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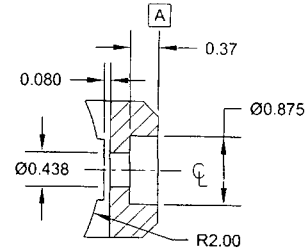
**SECTION A-A** C3-2  
SCALE 4X C4-4  
C5-4



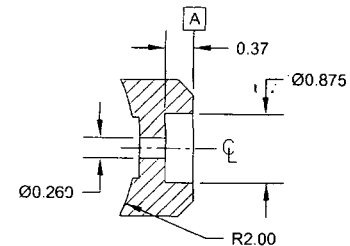
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SCALE 4X C5-4



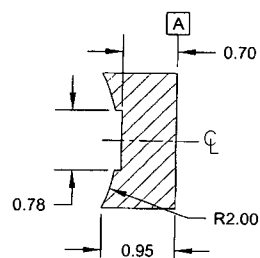
**SECTION C-C** C5-2  
SCALE 4X C4-2



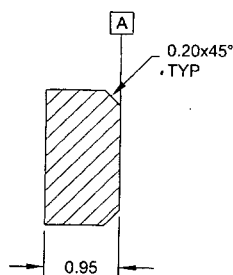
**SECTION D-D** C4-2  
SCALE 4X C3-4



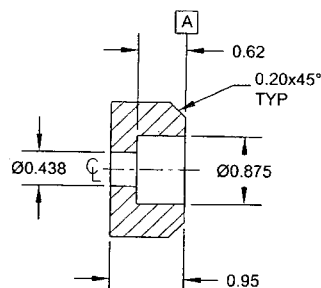
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SCALE 4X C5-4



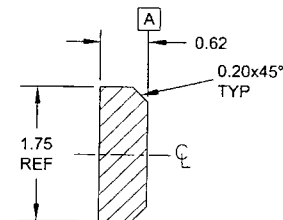
**SECTION F-F** C6-2  
SCALE 4X C3-4  
C5-5



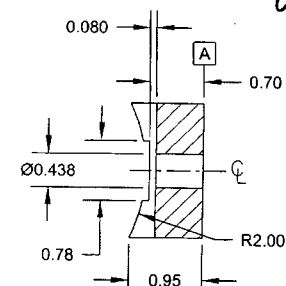
**SECTION G-G** C3-3  
SCALE 4X C4-3  
C5-3  
C6-3  
C7-3



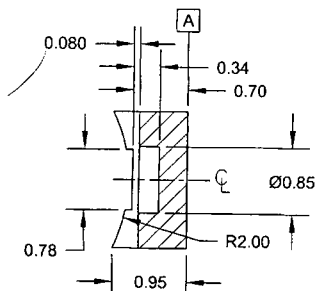
**SECTION H-H** C6-3  
SCALE 4X



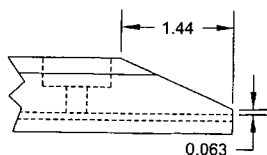
**SECTION K-K** B3-2  
SCALE 4X B4-2  
B5-2



**SECTION L-L** C5-5  
SCALE 4X



**SECTION N-N** B6-5  
SCALE 4X



**DETAIL J** B3-2  
SCALE 4X B7-4

RELEASED  
2011-11-02

DESIGN	4	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO. D2916	REV. D
MFG. APPR.	4		SHEET 6 OF 6
APPROVED	4	TITLE	SCALE
DE APPR.	4	CABLE GUARD	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries